

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010805**Date Inspected:** 15-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 053 located on Cross Beam CB202G – 046. Welder is identified as 215397. ZPMC Quality Control (QC) Inspector is identified as Tian lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 051 located on Cross Beam CB202G – 045. Welder is identified as 216575. ZPMC Quality Control (QC) Inspector is identified as Tian lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Shielded Metal Arc Welding (SMAW):

Weld joint # 017 located on Cross Beam CB202A – 015. Welder is identified as 216667. ZPMC Quality Control (QC) Inspector is identified as Tian lei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – Tc – U4b – Fcm.

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BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 006 located on Traveler Rail 11TR3 – 003. Welder is identified as 066359. ZPMC Quality Control (QC) Inspector is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 002 located on Bike Path BK001 – 035. Welder is identified as 066912. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 006 located on Bike Path BK001 – 033. Welder is identified as 067275. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

Weld joint # 014 located on Traveler Rail 11TR5 – 006. Welder is identified as 066359. ZPMC Quality Control (QC) Inspector is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 006 located on Bike Path BK001 – 032. Welder is identified as 067036. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

Weld joint # 003 located on Bike Path BK001 – 036. Welder is identified as 066734. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

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Reviewed By: Hall,Steven

QA Reviewer